

Work Order ID 69209

Wednesday, May 04, 2011 4:17:57 PM



Page 1

Item ID: D2989-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 5/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-05-4

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig

****cut cutouts with zip cut as per dwg D3832****

3- remove from jig and weld lable plate as per dwg D2989

A/R ER316 S.S. Rod Batch: 113928

*** PLEASE NOTE***

IF MAKING -043A :

ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER

DS19473

Cpl 11-05-10

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

BE
11-05-10

1 / 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept

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Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date: _____

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #**Plan
CodeAccept
QtyReject
QtyReject
Number

**Insp.
Stamp**

120

QC6- Inspect dimensions to drawing

0.00

510514

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

IX ~~0~~ m/k 11/05/11

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

Powder Coating

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

① ~~φ~~ m-f 11/05/11

131



HandFinish

Wing Walk as per dwg QSI005 4.4 Batch 111731000

Memo

0.00

Hand Finishing

Mask lid prior to spray paint black and wing walk as per dwg
A/R Spray paint black batch: M116123

x1 ~~φ~~ 11/05/11

M116964

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EF 5/11/05/12 @

141

Identify as per dwg & Stock Location: 6. A 0.00

Packaging

Memo

0.00

Packaging

*w/p
69207*

EF 11/05/12 @

150

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

*CK 11/05/16
ME
11-05-13*

W/O:		WORK ORDER CHANGES					
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Wednesday, May 04, 2011 4:18:34 PM



Required Date: 5/11/2011

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
 10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 		Manufactured	No			100	Each	14.0000	2	2		Pl 11.05.10	
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				14					
					67350			2					
					67465			12					
D2506 		Manufactured	No			100	Each	1.0000	1	1		Pl 11.05.10	
Label Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				1					
					65539			1					
D2512-7 		Manufactured	No			100	Each	8.0000	1	1		Pl 11.05.10	
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				8					
					65540			4					
					67445			4					

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Picklist Print

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Page 2

Work Order ID: 69209

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 5/4/2011

Required Date: 5/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 4.0000 2 2



Mounting Bracket



Pl 11.05.10

Location

Loc Qty

Loc Code

WA005

4

66806

4

B68964 → ②

D2989-13 Manufactured No 100 Each 0.0000 2 2



Rib



B69128 → ② Pl 11.05.10

D2989-19 Manufactured No 100 Each 0.0000 2 2



Rib



B67446 Pl 11.05.10 *

D3832-3 Manufactured No 100 Each 4.0000 1 1



Mesh (Lid)



Pl 11.05.10

Location

Loc Qty

Loc Code

WA

4

67066

1

67501

3

①

D3833-3 Manufactured No 100 Each 31.0000 2 2



Mesh (Lid End)



Pl 11.05.10

Location

Loc Qty

Loc Code

WA

31

64947

4

67460

27

②

D3836-041 Manufactured No 100 Each 0.0000 1 1



Rib Assembly (Basket Lid, LH)



B67447 → ① Pl 11.05.10

Wednesday, May 04, 2011 4:18:35 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 69209



Parent Item: D2989-041



Parent Item Name: Basket Lid Assembly

Start Date: 5/4/2011

Required Date: 5/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3836-042	Manufactured	No	100	Each	0.0000	1	1		B67448 → ① Pl 11.05.10
Rib Assembly (Basket Lid, RH)									
D3852-041	Manufactured	No	100	Each	0.0000	1	1		B67451 67449 Pl 11.05.10
Rib Assembly									
D3852-042	Manufactured	No	100	Each	0.0000	1	1		B67451 Pl 11.05.10
Rib Assembly									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

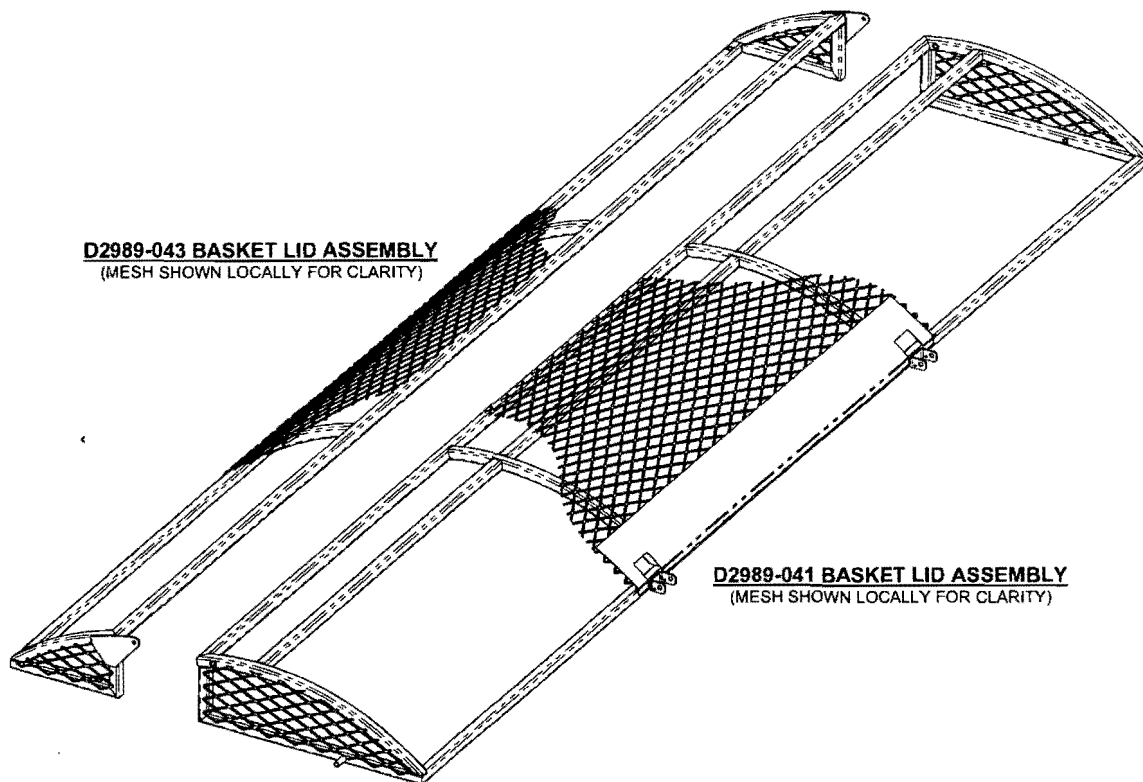
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/84

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
 SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 8) WELD PER DART QSI 004

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT

WITHOUT NOTICE
 WORK ORDER

NO. 62909

11-08-4

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL, MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.09.24		

W/O:		WORK ORDER CHANGES					
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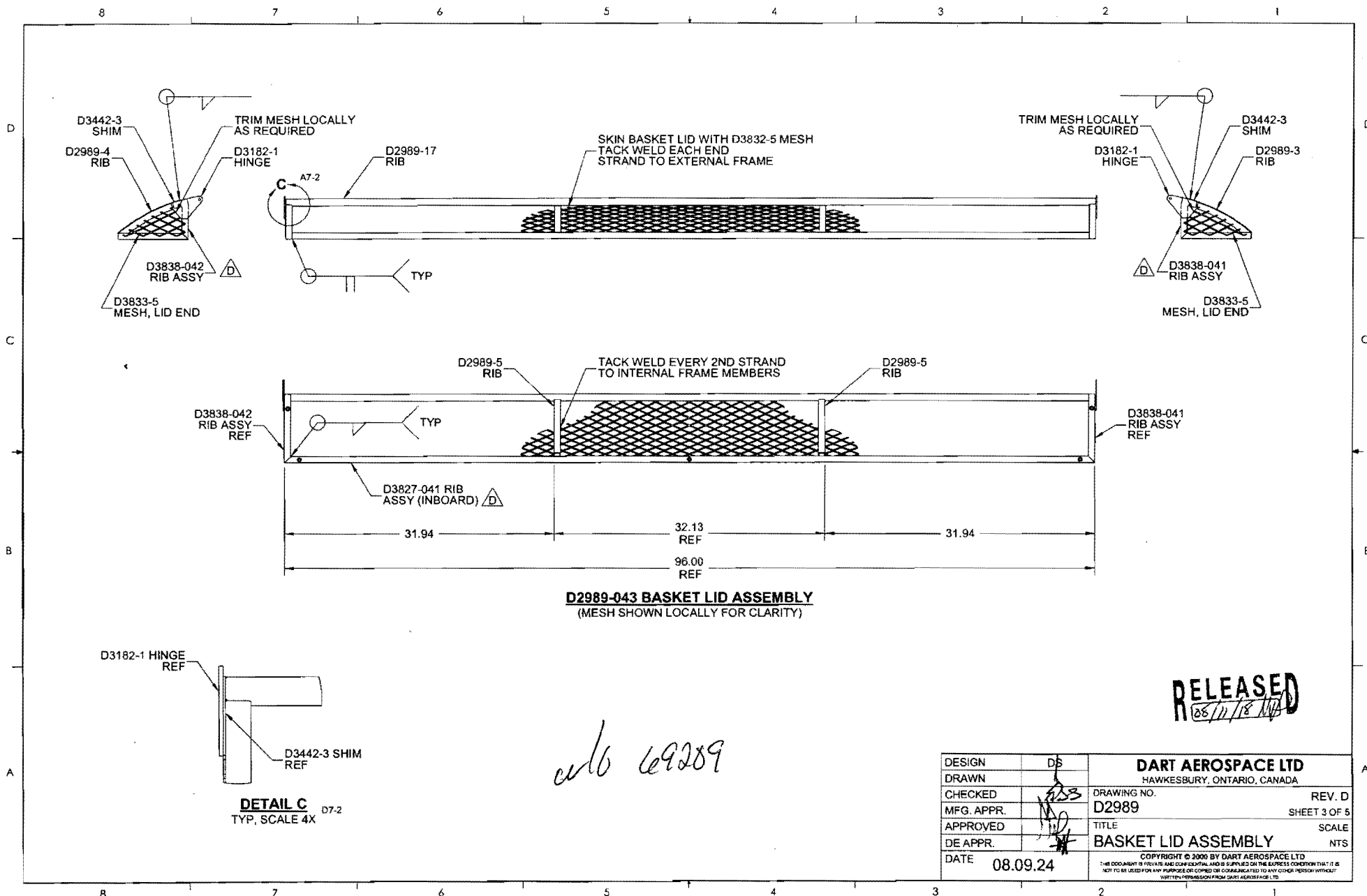
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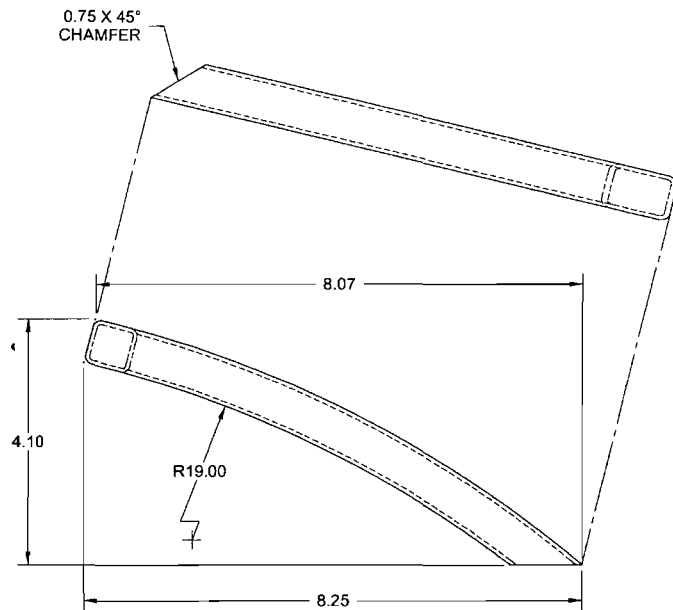
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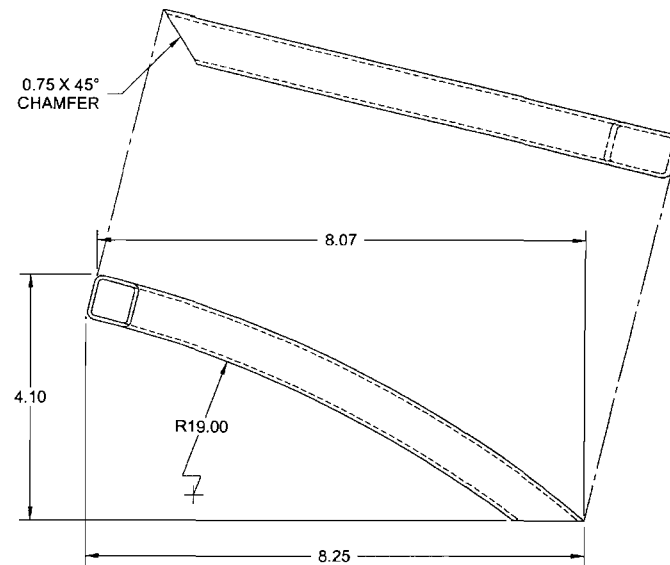
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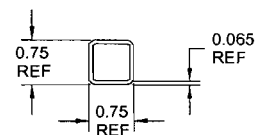


D2989-3 RIB



D2989-4 RIB



W/O 69209



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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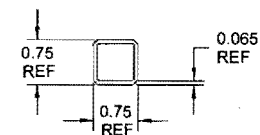
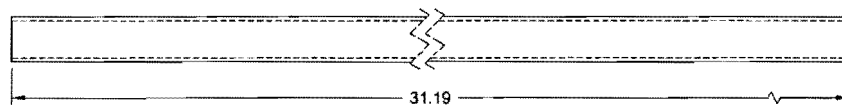
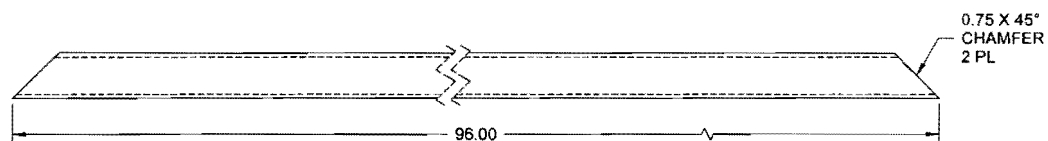
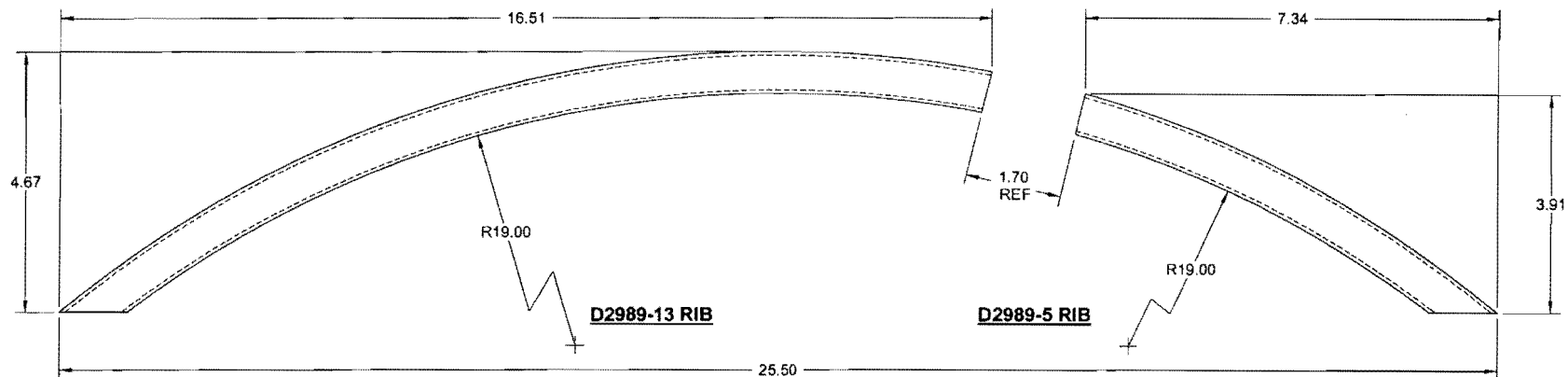
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**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

W6 69209

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO. D2989	REV. D
MFG. APPR.		SHEET 5 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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